

Technical Data Sheet

Schulblend M/MK 6503 U BLK72895

Acrylonitrile Butadiene Styrene + PA

Product Description

ABS/PA6 blend with high impact strength, UV stabilised. (Former name: SCHULABLEND M/MK SF UV)

Processing Method Injection Molding**Resin ID** PA+ABS

Typical Properties	Nominal Value	Units	Test Method
Physical			
Melt Volume Flow Rate, (260 °C/5.0 kg)	15	cm ³ /10 min	ISO 1133
Density, (Method A)	1.08	g/cm ³	ISO 1183
Mechanical			
Tensile Stress at Yield, (Type 1A, 50 mm/min)	40.0	MPa	ISO 527-2
Tensile Strain at Break, (Type 1A, 5 mm/min)	120	%	ISO 527-2
Flexural Modulus, (2.0 mm/min)	1300	MPa	ISO 178
Tensile Strain at Yield, (Type 1A, 50 mm/min)	4.0	%	ISO 527-2
Tensile Modulus, (1 mm/min, Type 1A)	1700	MPa	ISO 527-1
Flexural Stress			
(2.0 mm/min, 3.5%)	37.0	MPa	ISO 178
(2.0 mm/min, 7.0%)	46.0	MPa	ISO 178
Impact			
Charpy Impact Strength - Notched			
(23 °C, Type 1, Edgewise, Notch A)	80	kJ/m ²	ISO 179
(-30 °C, Type 1, Edgewise, Notch A)	18	kJ/m ²	ISO 179
Charpy Impact Strength - Unnotched			
(23 °C, Type 1, Edgewise)	No Break		ISO 179
(-30 °C, Type 1, Edgewise)	No Break		ISO 179
Hardness			
Ball Indentation Hardness, (H 358/30)	91.0	MPa	ISO 2039-1
Thermal			
Vicat Softening Temperature			
(B (50N), 50 °C/h)	140	°C	ISO 306
(A (10N), 50 °C/h)	200	°C	ISO 306
Deflection Temperature Under Load Unannealed (0.45 MPa), (Flatwise)	95.0	°C	ISO 75-2/B
Deflection Temperature Under Load Unannealed (1.80 MPa), (Flatwise)	68.0	°C	ISO 75-2/A
Electrical			

Volume Resistivity	>1.0E+13	ohm*m	IEC 62631-3-1
Surface Resistivity	>1.0E+15	ohm	IEC 60093

Flammable

Burning Rate			
(2.00 mm)	<100	mm/min	FMVSS 302
(2.00 mm)	<100	mm/min	ISO 3795

UL Information

Flammability Classification			
(1.5 mm)	HB		IEC 60695-11-10, -20
(3.0 mm)	HB		IEC 60695-11-10, -20

Injection Parameters	Nominal Value	Units
Drying Time	4	hr
Drying Temperature	80	°C
Processing (Melt) Temp	230 to 270	°C
Mold Temperature	40 to 80	°C